

Date: Tuesday, 10/3/2006 2:48:40 PM  
User: Kim Johnston

## Process Sheet

SPLIT

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 28819-2  
Estimate Number : 12505  
P.O. Number : N/A  
This Issue : 10/3/2006 S.O. No. : N/A  
Prsht Rev. : NC  
First Issue : N/A Type : SMALL/MED FAB  
Previous Run : 28116  
Drawing Name : N1 GEARBOX ACCESS PANEL KIT  
Part Number : D412705017  
Drawing Number : D3255 REV B  
Project Number : N/A  
Drawing Revision : B  
Material : N/A  
Due Date : 10/25/2006 Qty: 3 Um: Each  
Written By :  
Checked & Approved By :  
Comment : Est Rev: C Removed Manufacturing 06-08-02 JLM

Additional Product:

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

DC

DOCUMENT CONTROL



KS 06-10-11

Comment: Photocopy bluefile &amp; type labels per PPPD412-705-017

CHG001

or 06/10/10

2.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0

D3255041

Access Panel Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Access Panel Assembly

Batch: B28124 1P

B28124 2P 07/10/10

PO 7/10/03

4.0

D3255042

Access Panel Assembly



B28125 2X

Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Access Panel Assembly

B28125 1P

PO 7/10/03

07/10/10

5.0

AN3C3A

Bolt



Comment: Qty.: 30.0000 Each(s)/Unit Total: 90.0000 Each(s)

Bolt

Batch: M103668

07/08/28

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: N1 GEARBOX ACCESS PANEL KIT

Job Number: 28819

Part Number: D412705017

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 MS932109 Washer



Comment: Qty.: 30.0000 Each(s)/Unit Total: 90.0000 Each(s)  
Washer

M102382(70)

M105057(20)

7.0 MS20427M33 Rivet



Comment: Qty.: 48.0000 Each(s)/Unit Total: 144.0000 Each(s)  
Rivet  
Batch: M102328

8.0 MS21060L3K Nut Plate



Comment: Qty.: 24.0000 Each(s)/Unit Total: 72.0000 Each(s)  
Nut Plate  
Batch: M18575(15) - M105057(10) 57+

7/10/10 28

9.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

En 210/10 28

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and pack for shipping as per PPP D412-705-017

Location:

PPP Rev: A

7/10/10 28

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

28/10/11

Job Completion:

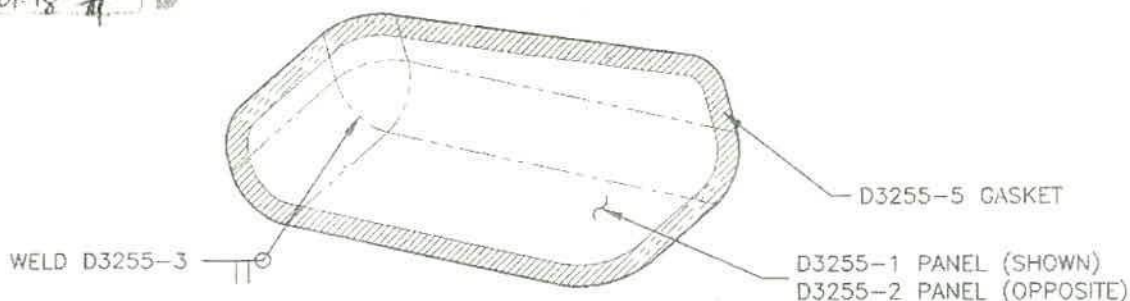


U 28/10/10

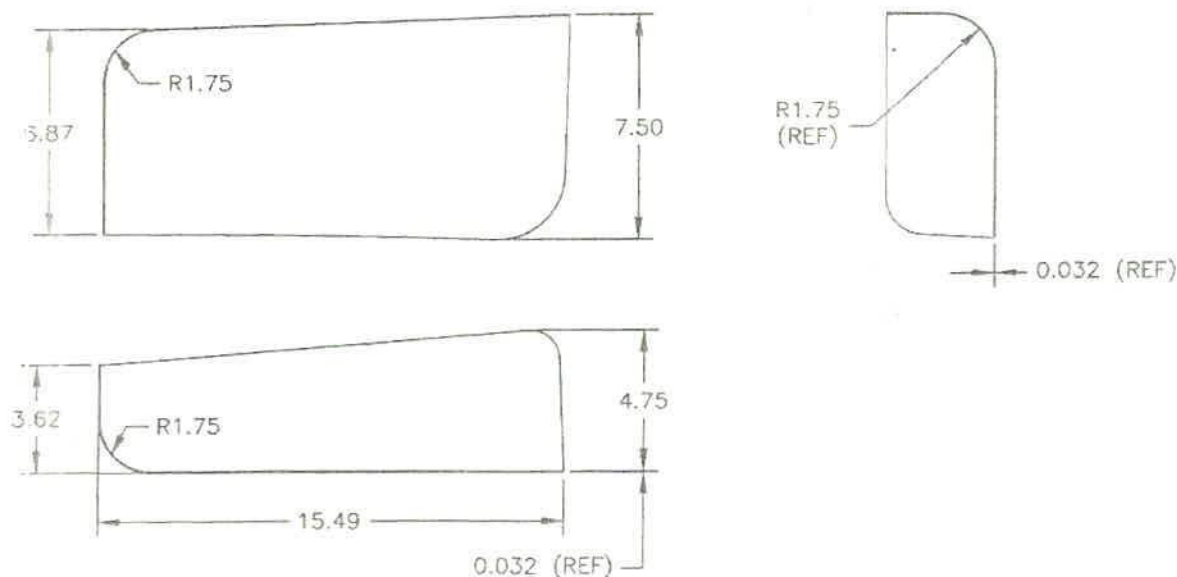


DESIGN H	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED if	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED $\phi 0.098$	

RELEASED  
05-01-18 H



D3255-041 ACCESS PANEL (SHOWN)  
D3255-042 ACCESS PANEL (OPPOSITE)



D3255-1 BEND DETAIL  
D3255-2 OPPOSITE

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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WITHOUT NOTICE  
WORK ORDER  
NO. 28819

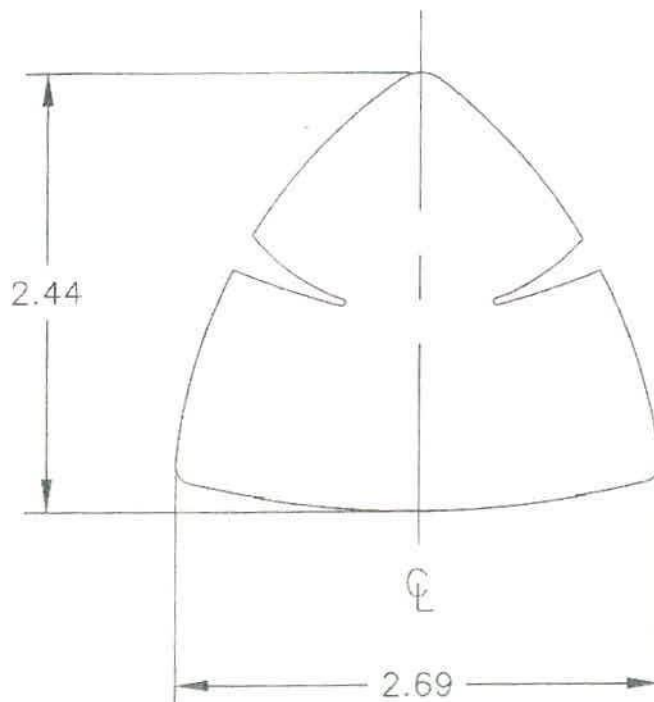
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**DART**

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CHECKED CP	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE 04.12.06		TITLE TITLE	SCALE 1:1

RELEASED  
05-01-08 [Signature]

**D3255-3 CAP**  
**FORM TO FIT D3155-1/-2**

**D3255-3 NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

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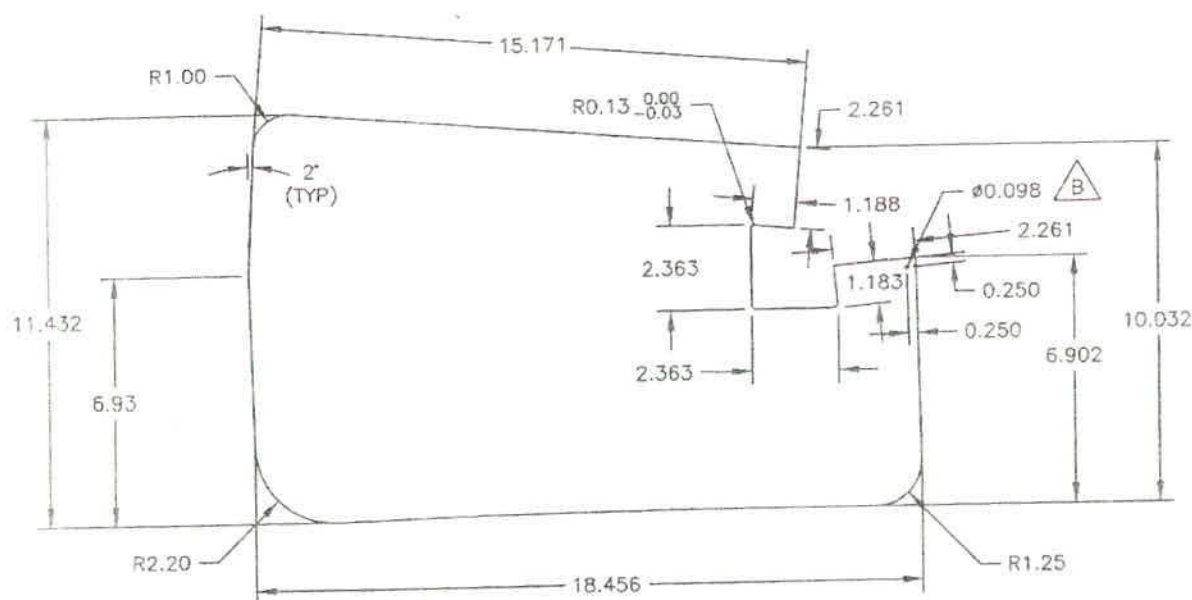
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DESIGN JF	DRAWN BY JF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED up	APPROVED JF	DRAWING NO. D3255	REV. B SHEET 3 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED  
05-01-18



### D3255-1/-2 FLAT PATTERN

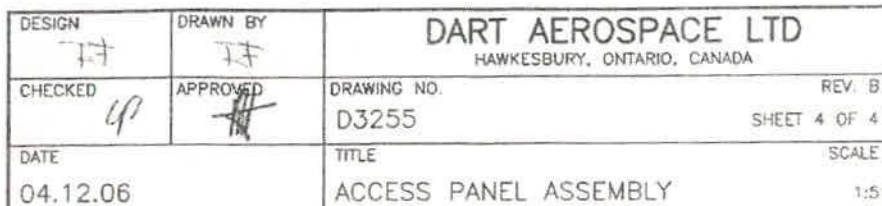
#### D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

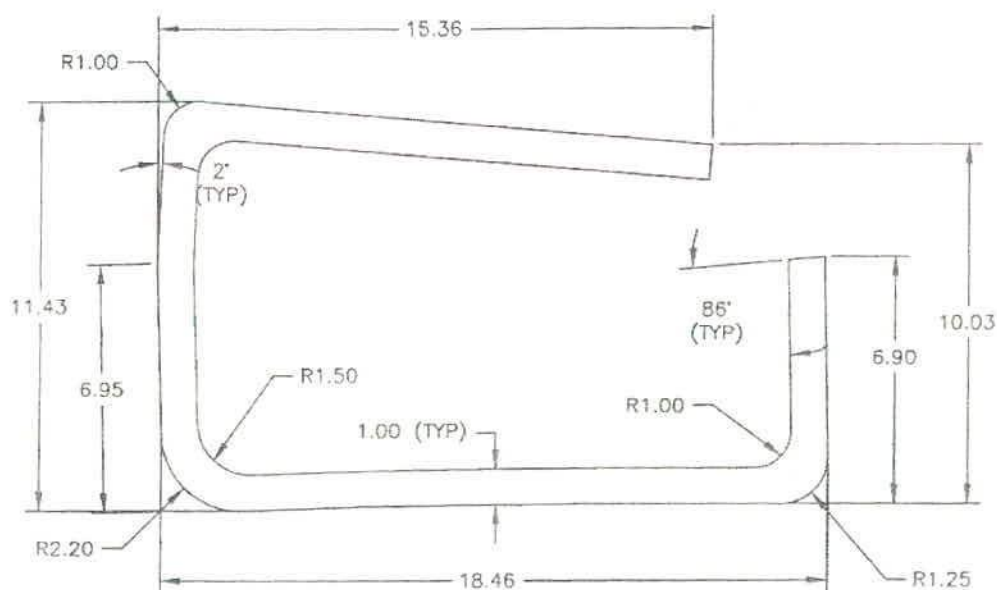
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RELEASED  
05 01 18 ~~11~~



D3255-5 GASKET

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
3) ALL DIMENSIONS ARE IN INCHES

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